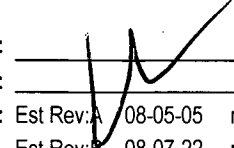


Date: Friday, 25/07/2008 10:54:26 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CUSHION ASSEMBLY
Job Number : 40732	
Estimate Number : 13303	
P.O. Number :	Part Number : D3781041
This Issue : 25/07/2008 S.O. No. :	Drawing Number : D3781 PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : PRELIM
Previous Run : 40732	Material :
Written By : 	Due Date : 01/08/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 08-05-05 new issue DD verified by:EC Est Rev:B 08-07-22 revB as per dwg DD verified by:EC	

PRELIMINARY ISSUE



Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 6835

Shipe with D3781-1 SUPPORTING PLATE 40734

Material: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT) AND COVER D3781-1/-3 ASSEMBLY WITH
 SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-11. BOND FABRIC USING 3M ADHESIVE
 (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

Possible Supplier: AEROTEX INTERIORS INC.

Material release note is required

AS 08/08/12 (X) JUO 08.7.25

2.0 D37813-1 Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CUSHION

BATCH: _____

N/A MANUFACTURED BY AEROTEX 08.09.09
 INTERIORS. SEE P/O 6835 @ STEP 1.0 ABOVE

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

AS 08/08/12 (X)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D3781

08.09.09 (1)

Date: Friday, 25/07/2008 10:54:26 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUSHION ASSEMBLY

Job Number: 40732

Part Number: D3781041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ENG USE ONLY

00224A

CP 09.02.27

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02

Job Completion



POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

MF 09-02-27

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 08.07.21	Job No.: 00224	ADR Yes/No: <input checked="" type="checkbox"/> N	ADR Date: N/A	ECN #: 08- 501P
Product No.: D412-761		Created By: <i>[Signature]</i>	Approved By: <i>[Signature]</i>	
Product Name: VERTICAL REFERENCE DOOR		Checked By: <i>[Signature]</i>	General Manager Approval:	

Distribution	Reqd	Resp	Initial / Date	Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL		DQA / QA Coord	N		
Production Engineering Coord	Y	DD/JLM		QC Coordinator	N		
Production Document Control	N			Marketing	N		
Customer Technical Support	N			Customer Order Processing	N		

Reason for Change:
MANUFACTURING OF PARTS ON POSITIVE RECALL

Documents Affected:
RELEASE PRELIM ISSUES OF D3696, D3780, D3781 & D3785 REV. B
RELEASE PRELIM ISSUES OF D3799 & D3801 REV. A

PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	N			
9	Update Blue/Pink/DSI Folder and Electronic Files	N			
10	Update Controlled PDF Files	N			
11	Update Master Document List (MDL)	N			
12	Update Document Record (DR)	N			
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	Y			08.07.21 <i>[Signature]</i>
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	N			
18	Create / Update PPP's	N			
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	N			
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	N			
22					
23					

Description / Action:

- PROCEED WITH MANUFACTURING OF D3696-041/-1.
- PROCEED WITH MANUFACTURING OF D3781-1F/-1. INSTALL NUTPLATES ON D3781-1 AND SEND TO AEROTEX FOR COMPLETION.
- PROCEED WITH MANUFACTURING OF D3785-3F/-3.
- ASSEMBLE D3780-041 ARMREST PER D3780 REV. B.
- RESTOCK P/Ns BNT-137, WIP-10 & PRT-2 UNDER D3799-1, D3801-1 & D3801-3 RESPECTIVELY. *DL w/o 40735-40736-40737*

*BNT 137 = 1x M107881
6x M107978*

PRT-2 =

WIP-10 =

ECN Verified & Complete: _____ Date: _____



#24, 2333 - 18 Ave NE
Calgary, AB T2E 8T6
Phone: (403) 295-8770
Fax: (403) 313 0793

Estimate

Date	Estimate #
5/7/2008	1472

REFERENCE ONLY

Name / Address	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada	
Customer Phone	Customer Fax
1-613-632-3336	1-613-632-4443

Item	Description	Part Number	Qty	Rate	Total
	ATTN: CHANTAL *The following are price breaks for the cushion you requested, the reason why we made the price break up to 30 is because in order for us to make the cushions, we have to order one sheet of foam and one sheet of foam can produce up to 30 cushions* ***CUSHION WILL ONLY WORK GOOD WITH OPTION A BECAUSE IT IS A VINYL AND WILL STRETCH BETTER ON TO FOAM***				
Other	FOAM;				
Other	QTY 1	D3781	1	430.00	430.00
Other	QTY 5	D3781	5	134.00	670.00
Other	QTY 10	D3781	10	91.00	910.00
Other	QTY 20	D3781	20	69.50	1,390.00
Other	QTY 30	D3781	30	57.00	1,710.00
	COVERS WITH INSTALLATION:*				
Other	QTY 1	D3781-3	1	250.00	250.00
Other	QTY 5	D3781-3	5	175.00	875.00
Other	QTY 10	D3781-3	10	130.00	1,300.00
Other	QTY 20	D3781-3	20	100.00	2,000.00
Other	QTY 30	D3781-3	30	80.00	2,400.00
	SURREYSILVER SUNSET VINYL PN: SY-111				
	GST On Sales			5.00%	596.75
We're looking forward to doing business with you!			Subtotal		
			\$11,935.00		
			Total		
			\$12,531.75		

GST/HST No. 139110308



#24, 2333 - 18 Ave NE
Calgary, AB T2E 8T6
Phone: (403) 295-8770
Fax: (403) 313 0793

Estimate

Date	Estimate #
5/7/2008	S1472

Name / Address	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada	
Customer Phone	Customer Fax
1-613-632-3336	1-613-632-4443

Item	Description	Part Number	Qty	Rate	Total
	ATTN: CHANTAL *The following are price breaks for the cushion you requested, the reason why we made the price break up to 30 is because in order for us to make the cushions, we have to order one sheet of foam and one sheet of foam can produce up to 30 cushions* ***CUSHION WILL ONLY WORK GOOD WITH OPTION A BECAUSE IT IS A VINYL AND WILL STRETCH BETTER ON TO FOAM***				
Other	FOAM;				
Other	QTY 1	D3781	1	430.00	430.00
Other	QTY 5	D3781	5	134.00	670.00
Other	QTY 10	D3781	10	91.00	910.00
Other	QTY 20	D3781	20	69.50	1,390.00
Other	QTY 30	D3781	30	57.00	1,710.00
Other	COVERS WITH INSTALLATION:*				
Other	QTY 1	D3781-3	1	250.00	250.00
Other	QTY 5	D3781-3	5	175.00	875.00
Other	QTY 10	D3781-3	10	130.00	1,300.00
Other	QTY 20	D3781-3	20	100.00	2,000.00
Other	QTY 30	D3781-3	30	80.00	2,400.00
	SURREYSILVER SUNSET VINYL PN: SY-111				
	GST On Sales			5.00%	596.75
We're looking forward to doing business with you!		Subtotal			
		\$11,935.00			
		Total			
		\$12,531.75			

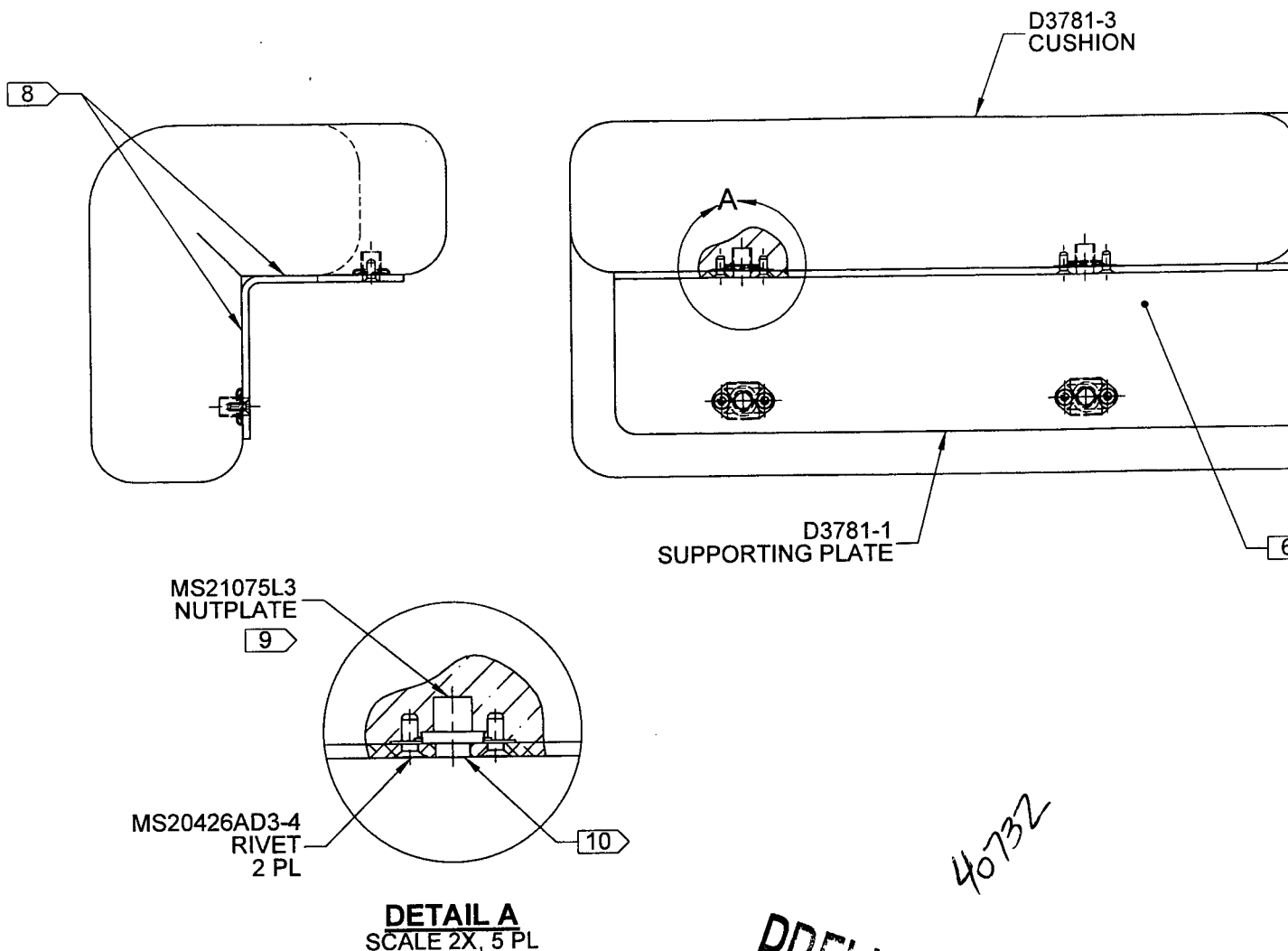
GST/HST No. 139110308

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B

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40732

PRELIMINARY ISSUE

D3781-041 NOTES:

1) MATERIAL:

- OPTION A: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
BOND FABRIC USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- OPTION B: COVER D3781-1/-3 ASSEMBLY WITH AMERBELLE 420/420 56/44 NYLON PACKCLOTH IN DARK DULL
BOND FABRIC USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 1.00 lbs

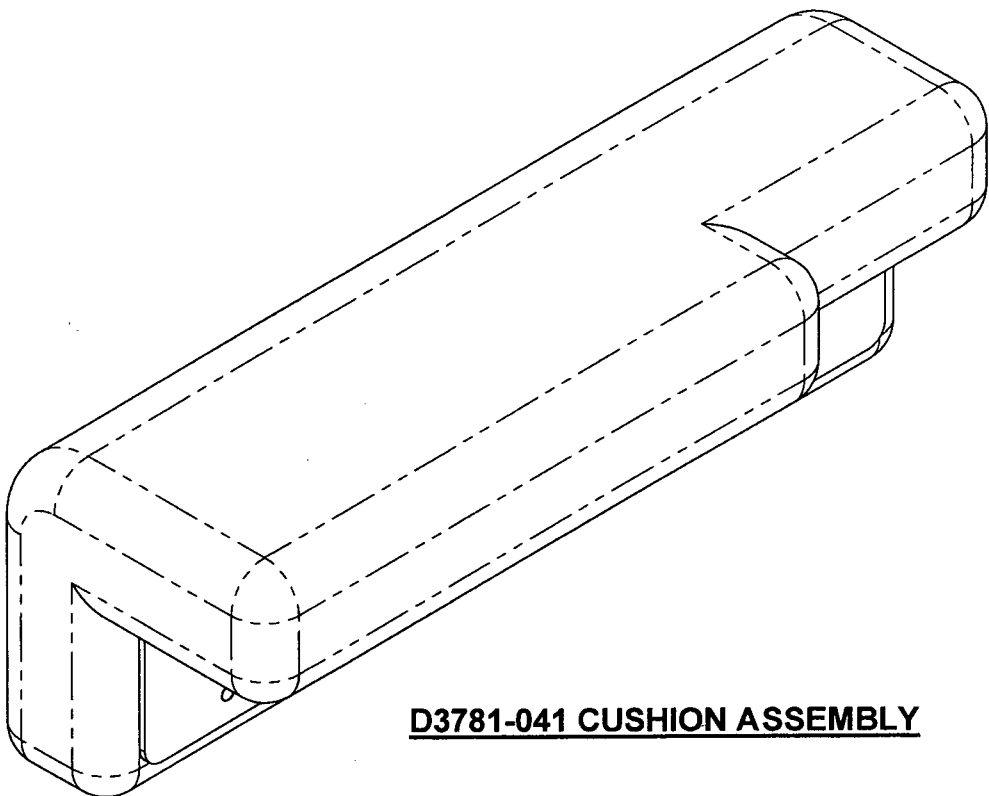
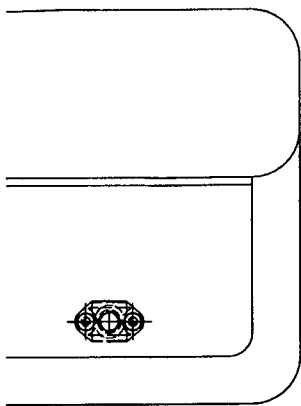
8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER BOND TO D3781-1 SUPPORTING PLATE

10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

11) THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH

QTY -041	P/N	DESCRIPTION
X	D3781-041	CUSHION ASSEMBLY
1	D3781-1	SUPPORTING PLATE
1	D3781-3	CUSHION
10	MS20426AD3-4	RIVET
5	MS21075L3	NUT PLATE (OR MS21075-3)
A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
A/R	1300	3M SCOTCH-GRIP ADHESIVE



D3781-041 CUSHION ASSEMBLY

PRELIMINARY ISSUE
08.07.16 40372

REVIEWER'S INSTRUCTIONS
BY REVIEWER'S INSTRUCTIONS
NO LOOSE THREADS

IN ACCORDANCE WITH
CONTACT WITH
NO LOOSE THREADS

B	REDESIGNED; ADDED DETAIL A (ZN D6-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3781	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
DATE	08.07.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

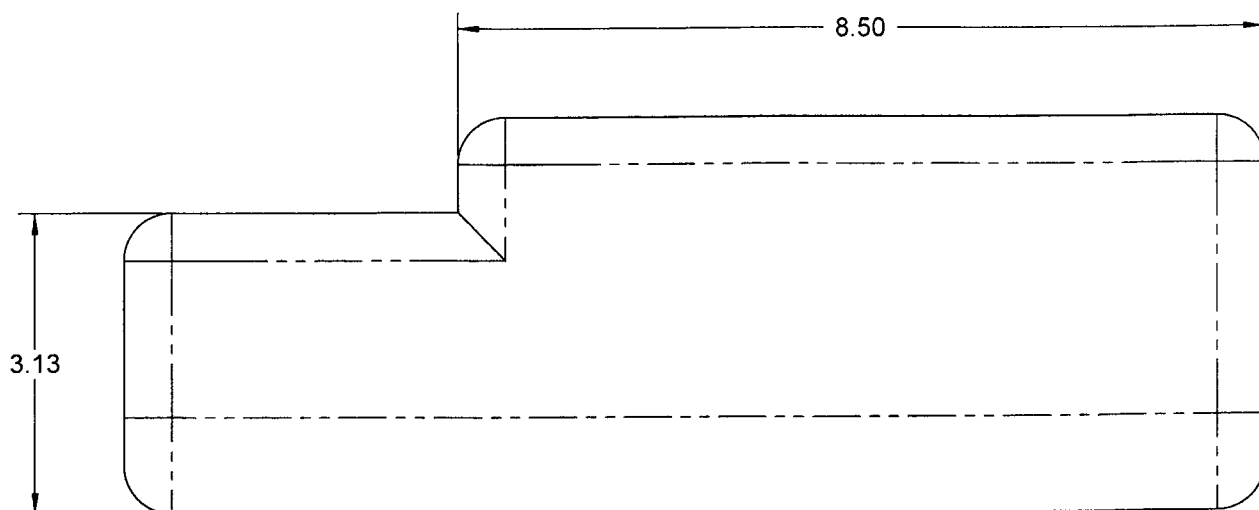
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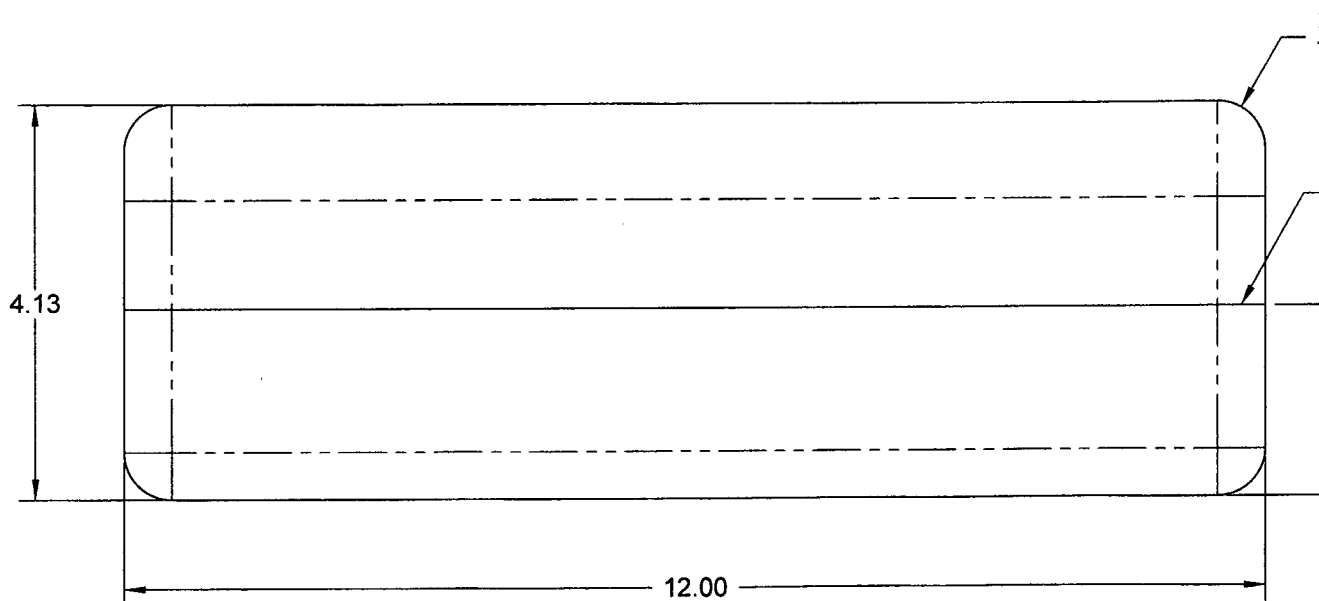
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D3781-3 CUSHION

40732

PRELIMINARY ISSUE

D3781-3 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.72 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 9) CUSHION MAY BE ASSEMBLED BY BONDING A 2.00" PIECE OF FOAM TO A 2.13" PIECE OF FOAM AS SHOWN A ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

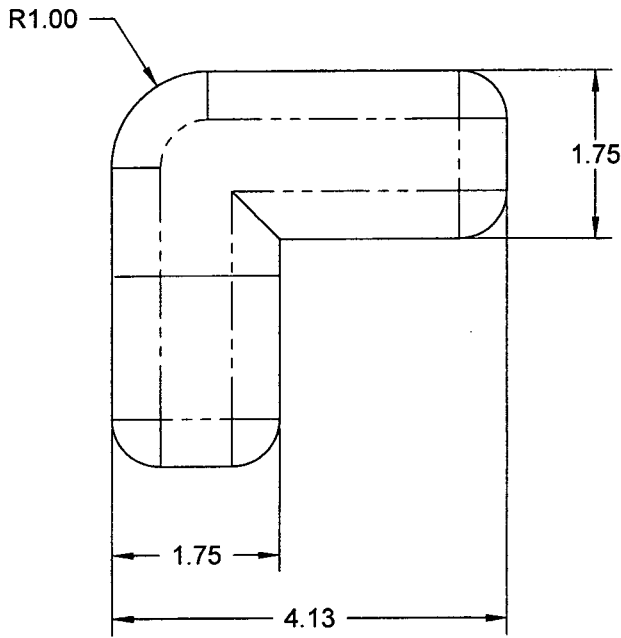
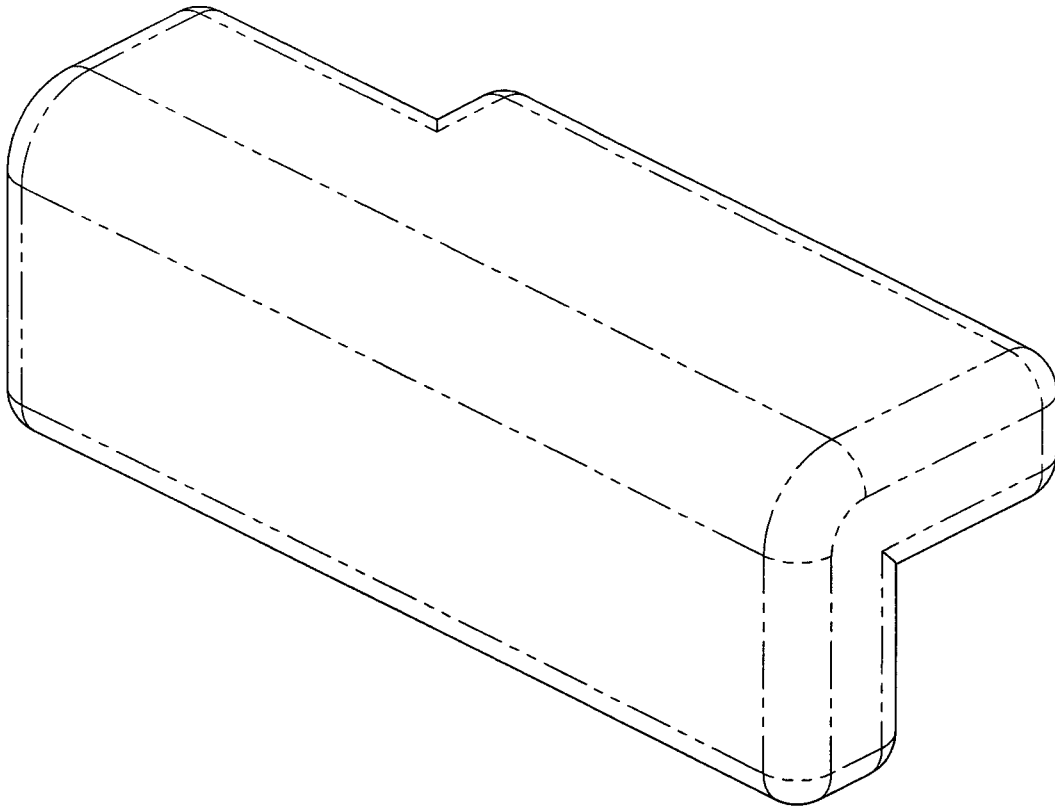
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OPTIONAL
VD LINE 9

40732

PRELIMINARY ISSUE
08.07.16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3781	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
DATE	08.07.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

USE USING 3M 1300 SCOTCH-BRITE

L Lacelle

From: Marc Bellavance [mbellavance@dartaero.com]
Sent: July 23, 2008 8:00 AM
To: 'L Lacelle'
Cc: 'Mike Petsche (E-mail)'
Subject: RE: estimate #S1472

Yeah...

We must know:

- 1) If the assembly adequately fit into its environment (i.e. no interference with collective, etc.)
- 2) If the assembly is satisfactory on a comfort point of view based on a pilot's feedback (i.e. flight testing next Sept or Oct with MikeO).

Once we've acquired that data we will be able to proceed with a more substantial PO or adjust our design accordingly.

Thanks!

Marc Bellavance
Mechanical Designer/Technical Support

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 240
Fax: 613-632-9311
E-mail: mbellavance@dartaero.com
Web: www.dartaero.com

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: July 23, 2008 7:53 AM
To: 'Marc Bellavance'
Cc: 'Mike Petsche (E-mail)'
Subject: RE: estimate #S1472

For 1 only?

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: July 23, 2008 7:39 AM
To: 'L Lacelle'
Cc: 'Mike Petsche (E-mail)'
Subject: RE: estimate #S1472

Wow! That's fast!
Go ahead with the PO.

Thanks Linda!

Marc Bellavance
Mechanical Designer/Technical Support

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 240
Fax: 613-632-9311

23/07/2008


E-mail: mbellavance@dartaero.com
Web: www.dartaero.com

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: July 23, 2008 6:49 AM
To: 'Marc Bellavance'
Subject: FW: estimate #S1472

From: Carson Chanthyvong [mailto:carsonc@aerotex.ca]
Sent: July 19, 2008 6:40 PM
To: 'L Lacelle'
Subject: RE: estimate #S1472

It should take about 2 – 4 business days once order is placed.

Carson Chanthyvong | Manager

 Aerotex Logo Outlook

24 - 2333 18 Avenue NE, Calgary AB T2E 8T6
Bus: 403.295.8770 | Fax: 403.313.0793
Web: <http://www.aerotex.ca>

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Tuesday, July 22, 2008 11:00 AM
To: 'Carson Chanthyvong'
Cc: 'Marc Bellavance'
Subject: estimate #S1472

Hi Carson,
What would lead time be on 1 cushion D3781 from your quote S1472? Please advise at your earliest convenience.

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

23/07/2008



#24, 2333 - 18 Ave NE
Calgary, AB T2E 8T6
Phone: (403) 295-8770
Fax: (403) 313 0793

Packing Slip

Date	Packing Slip#
8/11/2008	5532

Ship To	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada	
Customer Phone	Customer Fax
613.632.5200	613.632.1053
Ship Via	Courier Acct No.
FedEx	15179324-0

Invoice To
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada

Ship Date	P.O. No.
8/11/2008	6835

Item	Description	Part Number	Qty
Cushions	CUSHION ASSY. ✓ GST On Sales AS 8/11/08	D3781041 	1

Thank you for doing business with Aerotex Interiors!

www.aerotexinteriors.com

GST/HST No.

139110308



- Unit 24, 2333 - 18 Ave NE, Calgary AB T2E 8T6 - Phone: (403) 295 - 8770 - Fax: (403) 313 - 0793 -

CERTIFICATION OF CONFORMANCE

Customer Purchase Order: _____

Our Work Order: _____

6835

5532

THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK ORDER STATED ABOVE:

MATERIAL SURREY SILVER SUNSET

FOAM HR150

HAS BEEN FABRICATED TO ESTABLISHED SPECIFICATION TO CONFIRM WITH
FAR 25.853 (A)

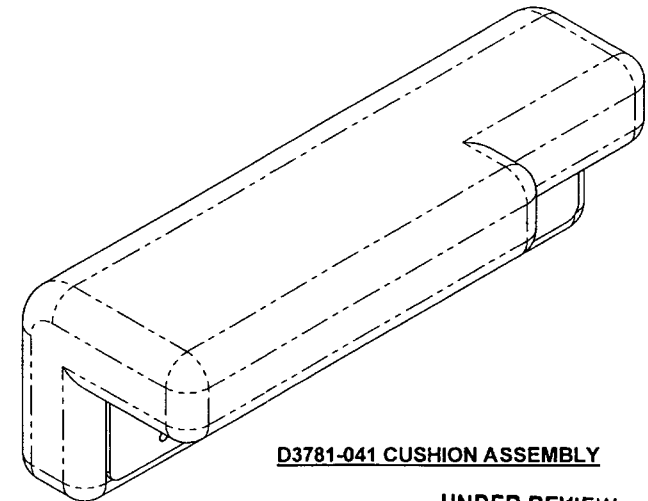
SOLD TO:

DART AEROSPACE LTD., 1270 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE

A large, stylized handwritten signature in black ink, written over a horizontal line.

QTY -041	P/N	DESCRIPTION
X	D3781-041	CUSHION ASSEMBLY
1	D3781-1	SUPPORTING PLATE
1	D3781-3	CUSHION
10	MS20426AD3-4	RIVET
5	MS21075L3	NUT PLATE (OR MS21075-3)
A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
A/R	1300	3M SCOTCH-GRIP ADHESIVE



D3781-041 CUSHION ASSEMBLY

UNDER REVIEW

09.01.14
FOR ECN 12 06 566

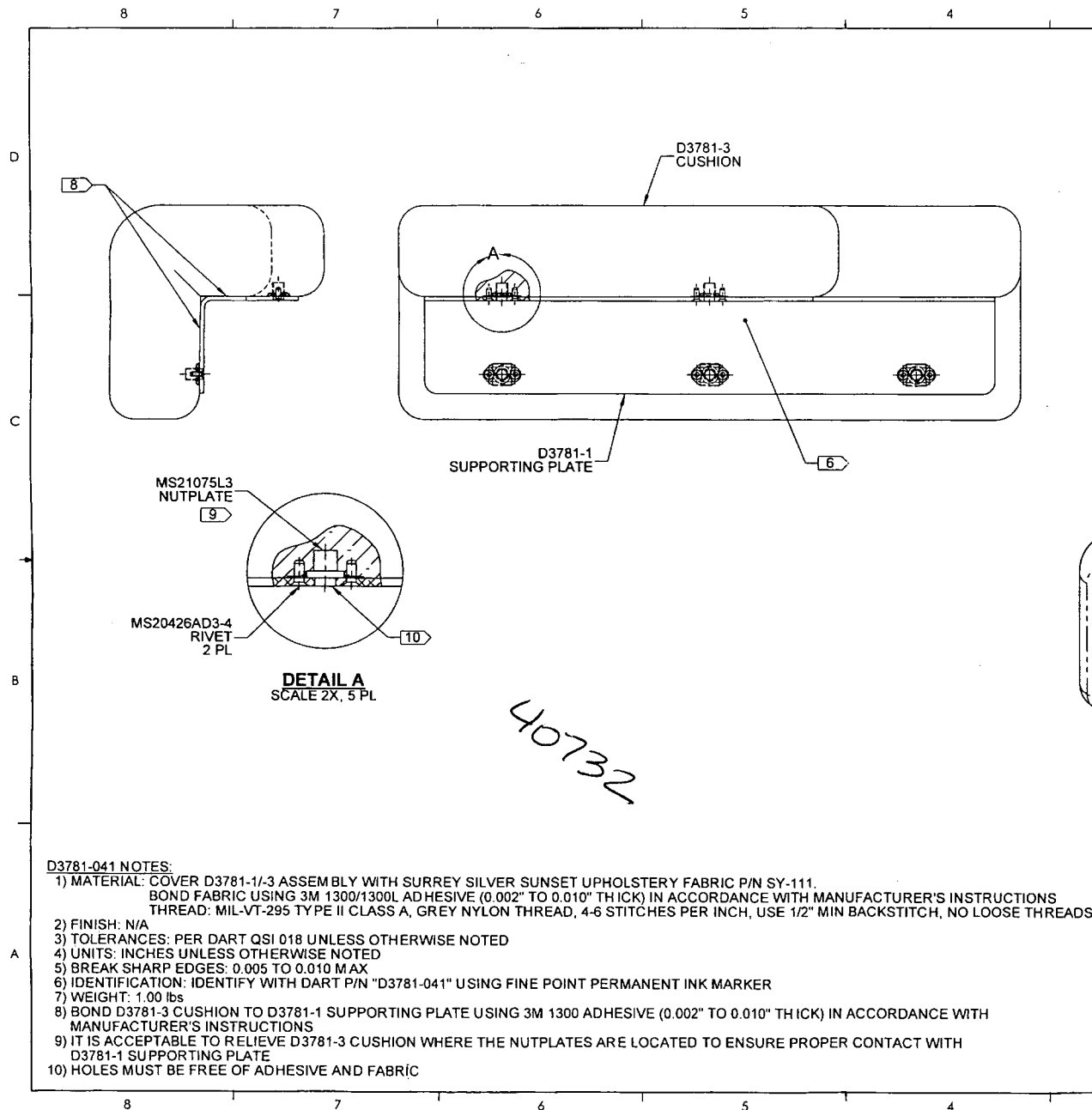
RELEASED
07/01/14

B	REDESIGNED, ADDED DETAIL A (ZN B7-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3781
REV. B
SHEET 1 OF 3
TITLE CUSHION ASSEMBLY
SCALE NTS

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D3781-041 NOTES:

- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.00 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

8 7 6 5 4 3 2 1

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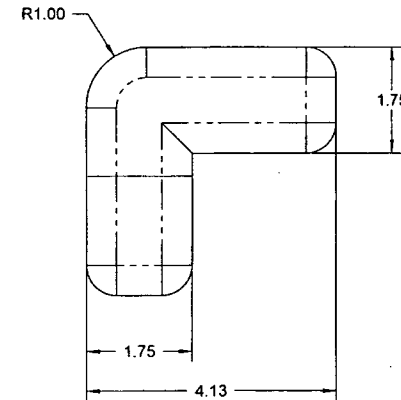
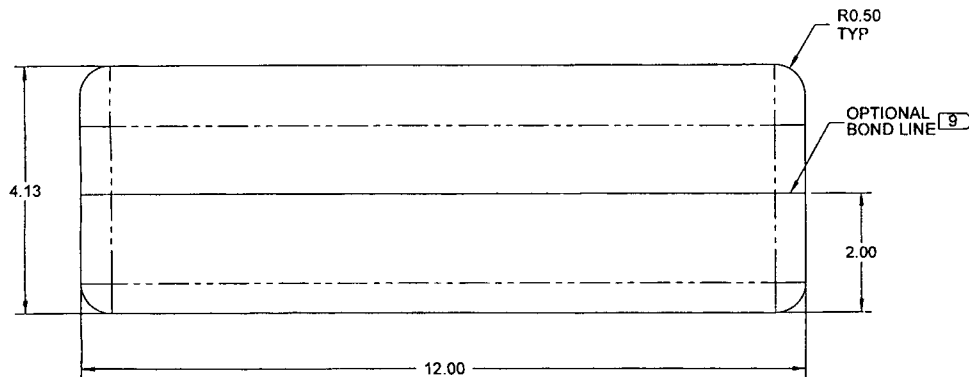
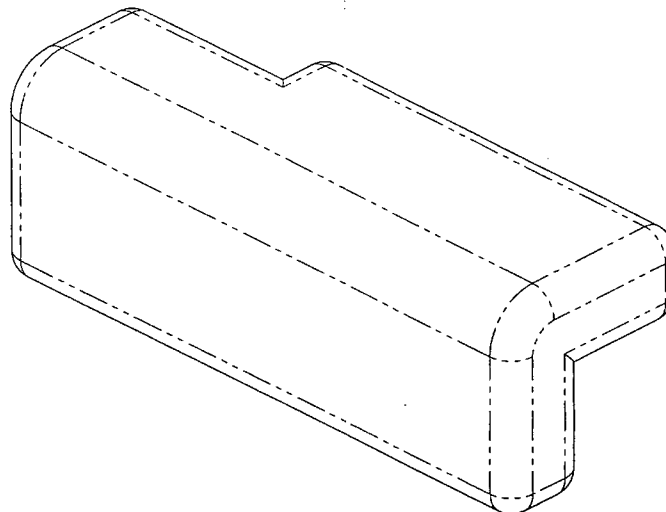
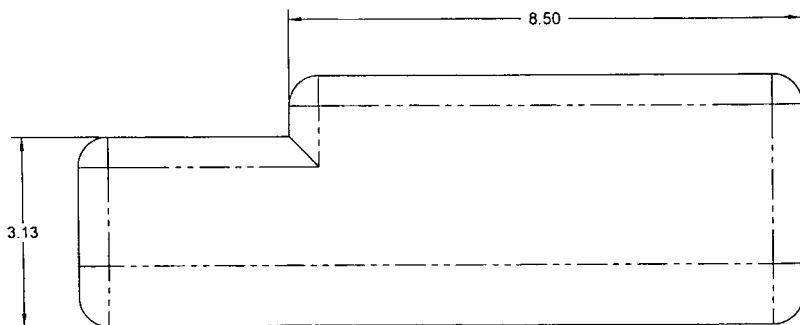
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D3781-3 CUSHION

UNDER REVIEW

09.01.14

RELEASED
09/01/14

40732

D3781-3 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.72 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 9) CUSHION MAY BE ASSEMBLED BY BONDING A 2.00" PIECE OF FOAM TO A 2.13" PIECE OF FOAM AS SHOWN ABOVE USING 3M 1300 SCOTCH-BRITE ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3781	REV. B
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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